

# Work Order ID 83270

April-16-12 1:37:20 PM

**\*83270\***

Page 1

Item ID: D2934 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle Spacer  
 Start Date: 16/04/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 30/04/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2934	Rev B								

100 FLOW WATER JET 0.00  
**\*100\***  
 Waterjet Memo 0.00 20 0 Jm 12  
 FLOW CNC Waterjet 1-Cut as per Dwg D2934 Dwg Rev: B Prog Rev: B 2- 12-5-12  
 (6061 . 50) Debur if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00 20 0 Jm 12  
 Quality Control 12-5-12

120 QC8- Inspect parts - second check 0.00  
**\*120\***  
 QC Memo 0.00 8 12/04/14 cuts  
 Quality Control (X20) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 16/04/2012    **Start Qty:** 20.00

\*20\*

**Cust Item ID:**

**Required Date:** 30/04/2012      **Req'd Qty:** 20.00

\*20\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

Chemical Conversion Coat per QSI005 4.1

0.00

\*130\*

## Memo

0.00

HandFinish

## Hand Finishing

QC3- Inspect Part Finish

0.00

**\*140\***

## Memo

0.00

QC

## Quality Control

Identify as per dwg & Stock Location.

0.00

**\*150\***

## Memo

0.00

### Packaging

## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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 Start Date: 16/04/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 30/04/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/5/15  
 ME  
 12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83270

\*83270\*

Parent Item: D2934

\*D2934\*

Parent Item Name: Saddle Spacer

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A00.06.06New IssueEC  
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	558.1500	0.0318	0.669474			
*M6061T6S 080*									**				
6061-T6 .080 Sheet													

## Location

## Loc Qty

## Loc Code

MAT021

558.15

117285

2.15

119766

39.77

120096

312.83

120349

11.4

121193

192

120096

5m 1st  
12-5-12

W/O:		WORK ORDER CHANGES						
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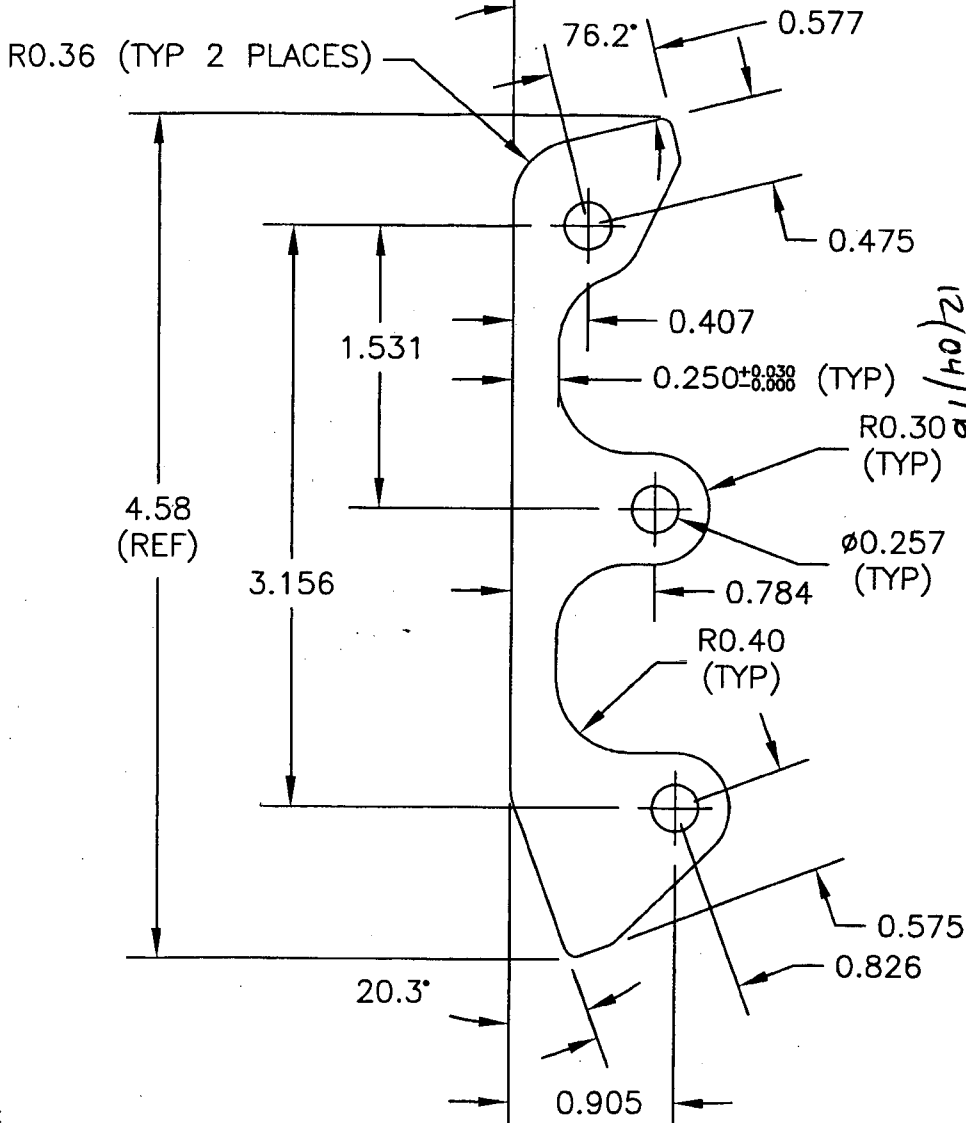
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**DART**

DESIGN 77	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SADDLE SPACER		SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**

06.06.20 [Signature]

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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# Dart Aerospace Ltd

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